



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3883-2**Job Sheet 187261****Part No:** D3883-2**Job Qty:** 10 ea**Part Name:** Saddle, Outside RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/29/18**Job Tracking No:****Due Date:** 1/31/19**Created By:** Jesse White**Type:** Stock**Description:**

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/31/19	0.00	0.00	Start Up Machining-2		<i>DR 19/01/16</i>
100	CNC Vertical Machining	10 pcs		1/31/19	0.64	22.73	HAAS1-5		<i>SBI 19/01/20</i>
110	QC	10 pcs		1/31/19	0.00	0.00	QC2 Machining-2		<i>SBI 19/01/21</i>
120	QC	10 pcs		1/31/19	0.00	0.00	QC8 Machining-2		<i>mml 19/01/23</i>
130	HandFinish	10 pcs		1/31/19	0.00	1.02	HandFinish1		<i>DR 19/01/23</i>
140	Powdercoat	10 pcs		1/31/19	0.00	0.38	Powdercoat1		<i>DEB 19-01-24</i>
150	QC	10 pcs		1/31/19	0.00	0.00	QC3		<i>38</i>
160	Packaging	10 pcs		1/31/19	0.00	0.00	Packaging3-2	<i>ST 404</i>	<i>DR 19/01/23</i>
170	QC21-SA	10 Ea		1/31/19	0.00	0.00	QC21		<i>21 JAN 28 2019</i>

Part Op 100 - Program Batch No. *51456551* - Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets 2-
Descriptions: Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817
and inspect per Dimension Sheets

110 - Inspect on CMM as per folio CMMA013.

140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M138997 START: 11:30 TEMP: 320° FINISH: 12:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	<i>S133664</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-015	10	7	0

Part Specifications

Specifications could not be found.

Plex 11/29/18 11:09 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Ord Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S145655 Part: D3883-2 Job No: 187261 Serial No/Batch: S145655 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/17/19					

DART AEROSPACE LTD		Work Order: 187 261
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		1,875	1,875	1,875	1,875		
B	1.433	1.443		1,438	1,438	1,438	1,438		
C	0.638	0.658		0,646	0,647	0,647	0,647		
D	3.895	3.905		3,900	3,900	3,900	3,900		
E	0.257	0.262		0,257	0,257	0,257	0,257		
F	0.605	0.625		0,616	0,615	0,615	0,614		
G	1.120	1.130		1,125	1,125	1,125	1,125		
H	2.245	2.255		2,250	2,250	2,250	2,250		
I	2.000	2.020		2,000	2,000	2,000	2,000		
J	0.140	0.165		0,152	0,149	0,149	0,149		
K	0.240	0.260		0,252	0,249	0,249	0,249		
L	0.115	0.135		0,125	0,127	0,125	0,125		
M	0.140	0.165		0,150	0,149	0,150	0,149		
N	0.720	0.780		0,770	0,775	0,770	0,770		
O	0.240	0.260		0,250	0,249	0,250	0,249		
P	0.110	0.140		0,137	0,138	0,135	0,137		
Q	0.178	0.198		0,188	0,188	0,188	0,188		
R	2.825	2.885		2,858	2,856	2,888	2,856		
S	0.316	0.321		0,316	0,316	0,316	0,316		
T	0.990	1.010		1,000	1,000	1,000	1,000		
U	1.745	1.755		1,750	1,750	1,750	1,750		
V	5.990	6.010		6,000	6,000	6,000	6,000		
W	1.245	1.255		1,250	1,250	1,250	1,250		
X	0.490	0.510		0,500	0,500	0,499	0,501		
Y	1.220	1.280		1,250	1,250	1,250	1,250		
Z	2.495	2.505		2,500	2,500	2,500	2,500		
AA	0.313	0.318		0,313	0,313	0,313	0,313		
AB	0.020	0.040		0,033	0,033	0,035	0,035		
AC	0.760	0.765		0,760	0,760	0,760	0,760		
AD	0.215	0.220		0,219	0,219	0,219	0,219		
AE	1.265	1.285		1,265	1,265	1,265	1,265		
AF									
Accept/Reject									

Measured by: DAS
Date: 57 19/01/20
9-89

Audited by: mpc
Date: 19/01/07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order: 187 26d
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 ¹	6 ²	7 ³	8 ⁴	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.648	0.648	0.648	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.615	0.614	0.615	0.614		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.149	0.148	0.149	0.149		
K	0.240	0.260		0.250	0.248	0.249	0.249		
L	0.115	0.135		0.125	0.125	0.126	0.127		
M	0.140	0.165		0.150	0.149	0.149	0.149		
N	0.720	0.780		0.772	0.770	0.770	0.775		
O	0.240	0.260		0.250	0.250	0.249	0.248		
P	0.110	0.140		0.138	0.138	0.138	0.138		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.856	2.858	2.856	2.858		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.000	1.000	0.999	0.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.500	0.502	0.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.035	0.033	0.033	0.033		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.219	0.219	0.219	0.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 19/01/20	Date: 9-89 19/01/23

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 187 261
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	3	4	By	Date
A	2.870	2.880		2.875	2.875				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		0.640	0.640				
D	3.895	3.905		3.900	3.900				
E	0.257	0.262		0.257	0.257				
F	0.605	0.625		0.613	0.614				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.000	2.000				
J	0.140	0.165		0.150	0.149				
K	0.240	0.260		0.250	0.249				
L	0.115	0.135		0.120	0.120				
M	0.140	0.165		0.149	0.149				
N	0.720	0.780		0.775	0.770				
O	0.240	0.260		0.249	0.250				
P	0.110	0.140		0.138	0.140				
Q	0.178	0.198		0.188	0.188				
R	2.825	2.885		2.850	2.850				
S	0.316	0.321		0.310	0.311				
T	0.990	1.010		1.000	0.999				
U	1.745	1.755		1.750	1.750				
V	5.990	6.010		6.000	6.000				
W	1.245	1.255		1.250	1.250				
X	0.490	0.510		0.500	0.501				
Y	1.220	1.280		1.250	1.250				
Z	2.495	2.505		2.500	2.500				
AA	0.313	0.318		0.313	0.313				
AB	0.020	0.040		0.035	0.035				
AC	0.760	0.765		0.760	0.760				
AD	0.215	0.220		0.219	0.219				
AE	1.265	1.285		1.265	1.265				
AF									
Accept/Reject									

Measured by: DAS 57	Audited by: <i>mjl</i>
Date: 9-89 19/01/20	Date: 14/01/29

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	<i>AA</i>